

Work Order ID 57394

Tuesday, April 06, 2010 11:17:54 AM



Page 1

Item ID: D2221

Accept



Setup

Start



Revision ID:

Item Name: 350 Basket Base

Stop



Start Date: 4/7/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PS

Date: 10-4-06 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2221

Rev H

100



Large Fab

Large Fab

0.00

Memo

0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: M113328

10/04/09

(1K)

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

10.04.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57394

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Page 2

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 4/7/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

8.06 hrs

(X)

Memo

0.00

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

⇒ 10.10 hrs

(X) 10

M114207

Memo

0.00

⌒ Plug holes prior to

1ST COAT:

START TIME: 11:30 AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 12:00 PM

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 12:45 PM

OVEN TEMPERATURE: 400°F

FINISH TIME: 1:15 PM

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: GA

0.00

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/04/12 *[Signature]*
MF 10-4-12

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Picklist Print

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Work Order ID: 57394



Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 4/7/2010

Required Date: 4/12/2010

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2221-1 Manufactured No 100 Each 7.0000 1.0000



Rib

Warehouse
Location
 Main Warehouse
 WA
 55977

Loc Qty

Loc Code

7

7

B55977 ① SY 10/04/07

D2221-5 Manufactured No 100 Each 2.0000 2.0000



Rib

Warehouse
Location
 Main Warehouse
 WA
 55652

Loc Qty

Loc Code

2

2

B56203 ② SY 10/04/07

D2221-7 Manufactured No 100 Each 0.0000 1.0000



Rib

D2232-3 Manufactured No 100 Each 9.0000 2.0000



Basket Hinge

Warehouse
Location
 Main Warehouse
 WA
 54863

Loc Qty

Loc Code

9

9

~~B55977~~
 B56202 ① SY 10/04/07

2x SY 10/04/07

B55977

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 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 4/7/2010

Required Date: 4/12/2010


Start Qty: 1.00

Required Qty: 1.00


D2235-1 Manufactured No 100 Each 11.0000 2.0000

 Basket Rib

B56472 ② SY 10/04/07

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA	11	
	55979	3	
	56472	8	

D2581 Manufactured No 100 Each 21.0000 2.0000

 Mounting Bracket

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA	21	
	46086	2	
	51745	2	
	55918	17	

D3442-1 Manufactured No 100 Each 26.0000 2.0000

 Shim

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA	26	
	54071	7	
	56579	19	

2x SY 10/04/07

2x SY 10/04/07

Tuesday, April 06, 2010 11:17:54 AM

Shop Packet Print

Page 2

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Start Date: 4/7/2010

Required Date: 4/12/2010

Start Qty: 1.00

Required Qty: 1.00

D3825-041



Rib Assembly (Basket End)

Manufactured No

100 Each 6.0000 2.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

6

56205

6

100 Each

2.0000 2.0000



2x SY 10/04/07

D3826-041



Rib / Gusset Assembly

Manufactured No

100 Each 2.0000 2.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

2

56207

2

100 Each

8.0000 1.0000



B 57281 (2x) SY 10/04/07

D3827-041



Rib Assembly (Inboard)

Manufactured No

100 Each 8.0000 1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

8

54866

2

55982

6

1x SY 10/04/07

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Shop Packet Print

Page 3

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 4/7/2010

Required Date: 4/12/2010

Start Qty: 1.00

Required Qty: 1.00

D3832-1



Mesh (Base)

Manufactured No

100 Each 2.0000 1.0000



SAD 10-04-09

Warehouse

Location

Main Warehouse

WA

56179

Loc Qty

Loc Code

2

2

100 Each

7.0000 2.0000



SAD 10-04-09

D3833-1



Mesh (Base End Face)

Manufactured No

Warehouse

Location

Main Warehouse

WA

55843

56396

Loc Qty

Loc Code

7

1

6

7
1
6

Tuesday, April 06, 2010 11:17:54 AM

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Page 4

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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RE 08/11/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 57394

B210-4-04

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2221-3; D3826-041 REPLACES D2221-1/D2221-1; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 06.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 16.52 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT.	AJS	08.06.18
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	BW	DRAWING NO.	REV. H
MFG. APPR.	BW	D2221	SHEET 1 OF 5
APPROVED	BW	TITLE	SCALE
DE APPR.	BW	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

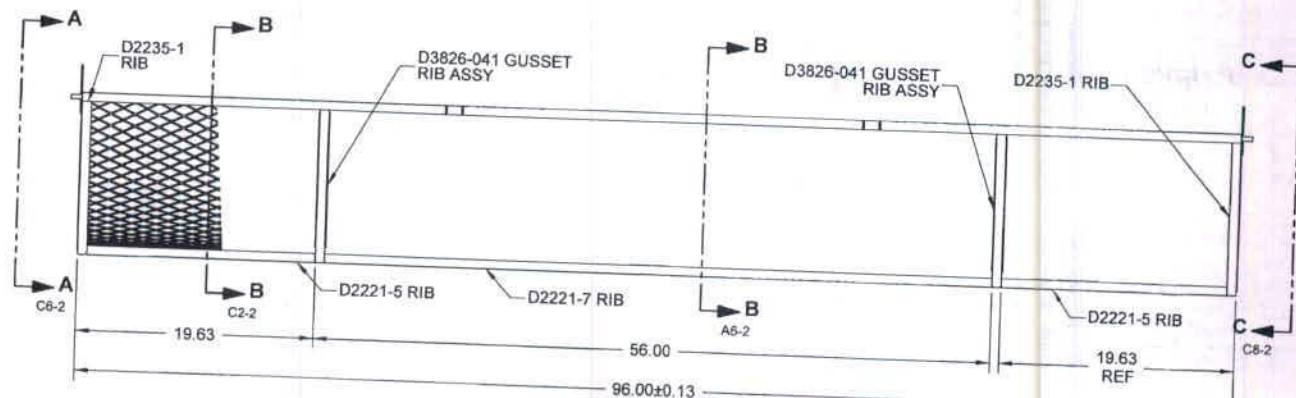
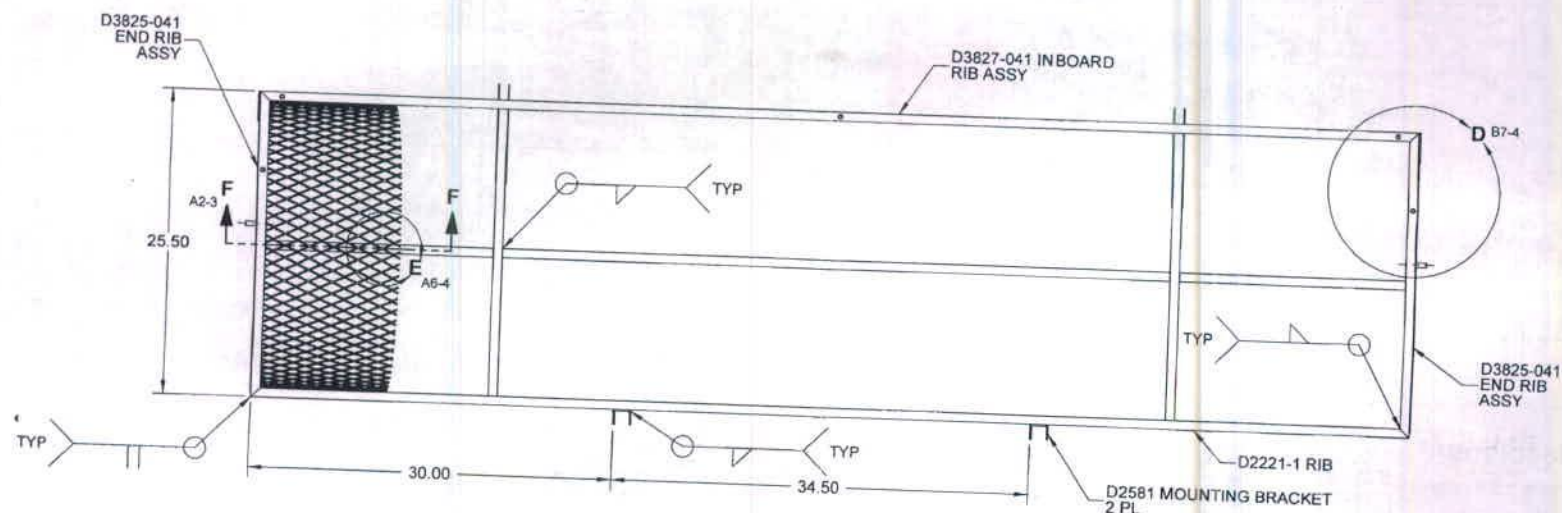
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18/14

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2221 TITLE BASKET BASE ASSEMBLY (350) DATE 08.09.18	REV. H
DRAWN			SHEET 2 OF 5
CHECKED			SCALE
MFG. APPR.			NTS
DE APPR.			

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Dart Aerospace Ltd

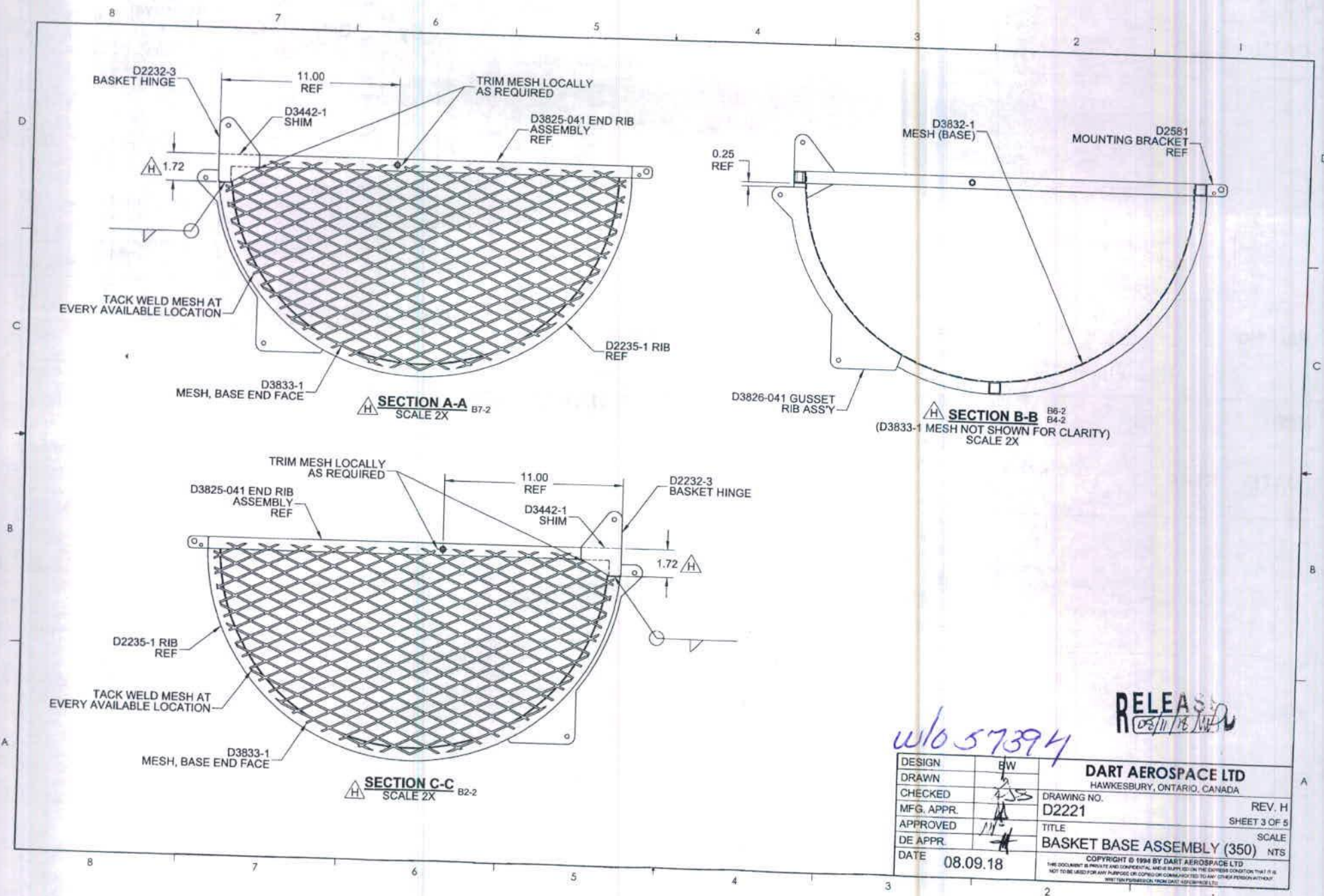
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NOTE: Date & initial all entries



RELEASED
03/11/16

u/o 57394

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. H
DRAWN	2		
CHECKED	455	DRAWING NO.	D2221
MFG. APPR.	A	TITLE	BASKET BASE ASSEMBLY (350)
APPROVED	11	SCALE	NTS
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD	
DATE	08.09.18	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS TO BE KEPT UNDER LOCK AND KEY AND NOT TO BE DISCLOSED OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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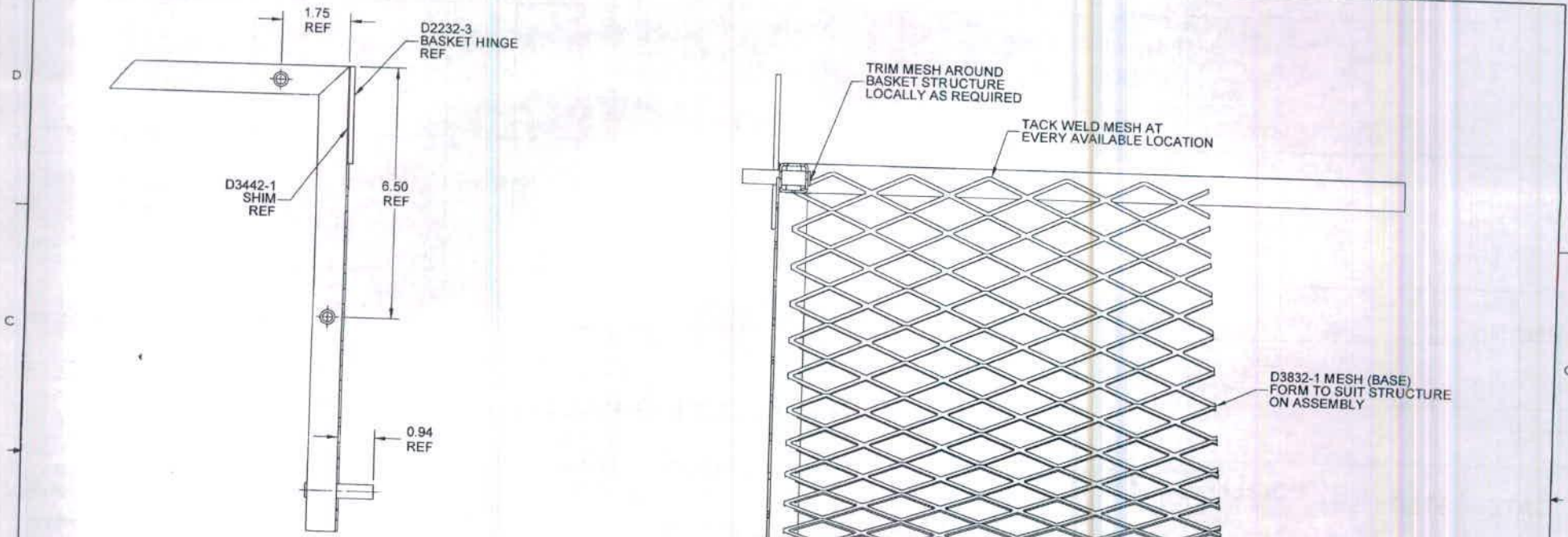
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

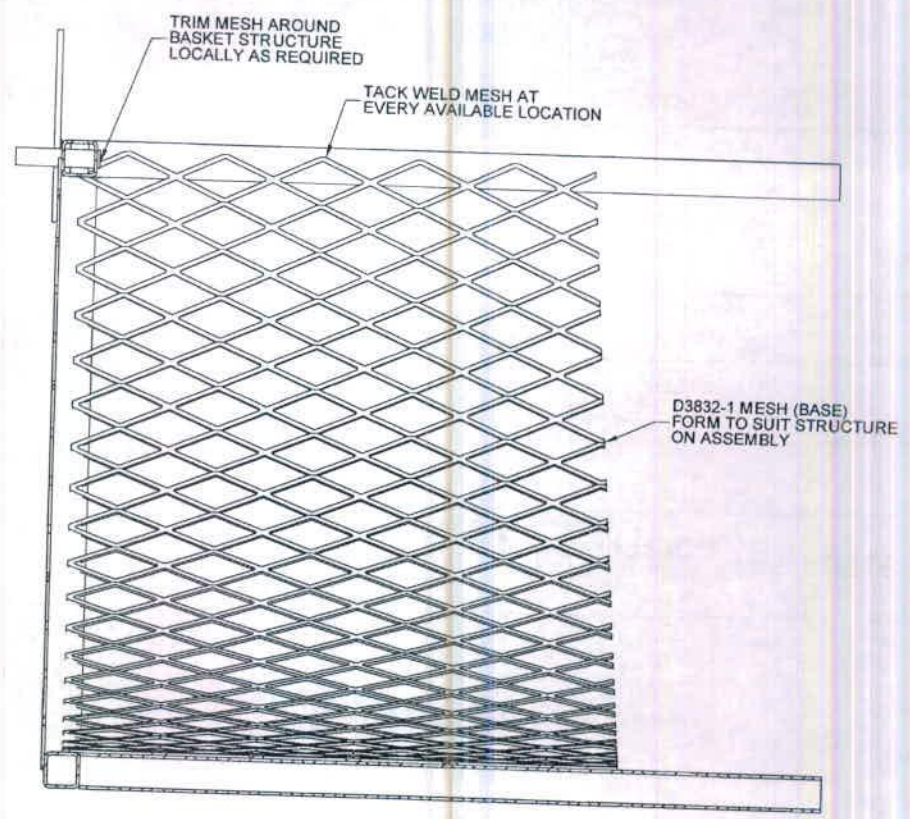
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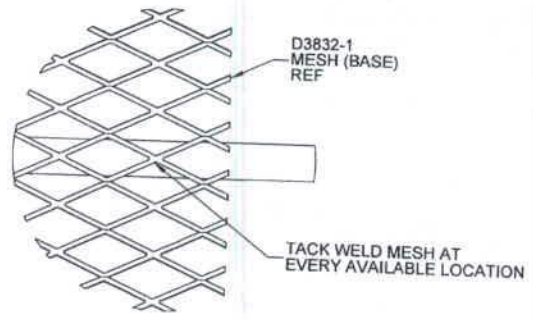
8 7 6 5 4 3 2 1



DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2



DETAIL E
SCALE 4X C6-2

RELEASED
02/11/88

w/o 57394

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2221	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1

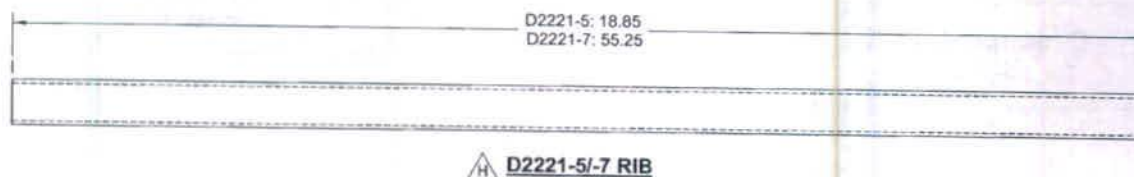
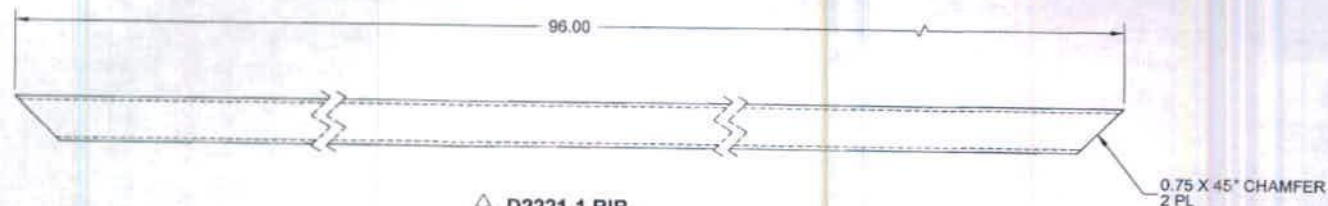
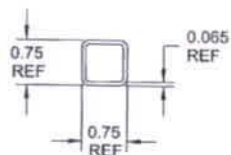
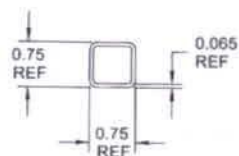
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	

RELEASED
06/10/18

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries